

5/43

DART AEROSPACE LTD	Work Order:	24503
Description: Hinge Bracket	Part Number:	D2858-1
Drawing: D2858 Rev. B	Qty:	24

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	[Signature]	05.10.12	24
2	METAL	Note: 1 Blank Makes 3 Parts Cut blanks 6.02" Material: 1.50" X 1.25" 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8) M16954 Batch M18600	En	05/10/21	24
3	HAAS	Machine per folio D2858-1	TBG	05.10.22	24
4	QC	Inspect Level 2	BG	05.10.22	24
5	METAL	Tumble and Deburr any rough edges after tumbling	TBG	05.10.22	24
6	METAL	Acid etch and alodine as per QSI 005 4.3	SAD	05/11/24	24
7	QC	Inspect Level 7	ML	05.11.21	24
8	FINISHING	Powder Coat White (Ref. 4.3.5.1) per Dart QSI 005 4.3	FC	05.11.22	24
9	QC	Inspect Level 3	ML	05.11.22	24
10	STORES	Identify and stock	[Signature]	05/11/23	24
11	EXPEDITING	Close W/O Cost / Part: 54505/11/24 (24)	[Signature]	05/11/24	24

Rev	Date	Change	Revised By	Approved
A	99.01.04	New	KS	
B	99.07.12	Added tumble and acid etch	DM	
C	00.06.22	Removed P/O for powder coat	EC	

RELEASED

EC JUN 26 2000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 13 Date: 05/11/24

NOTE: Date & initial all entries

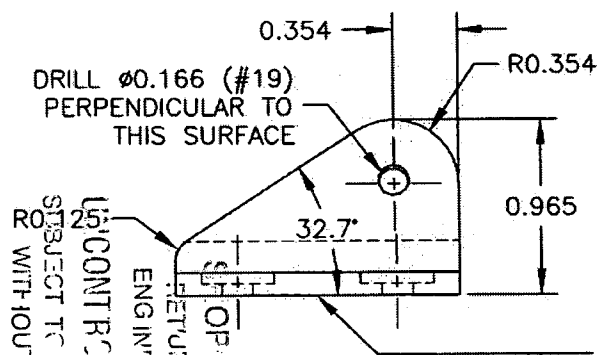
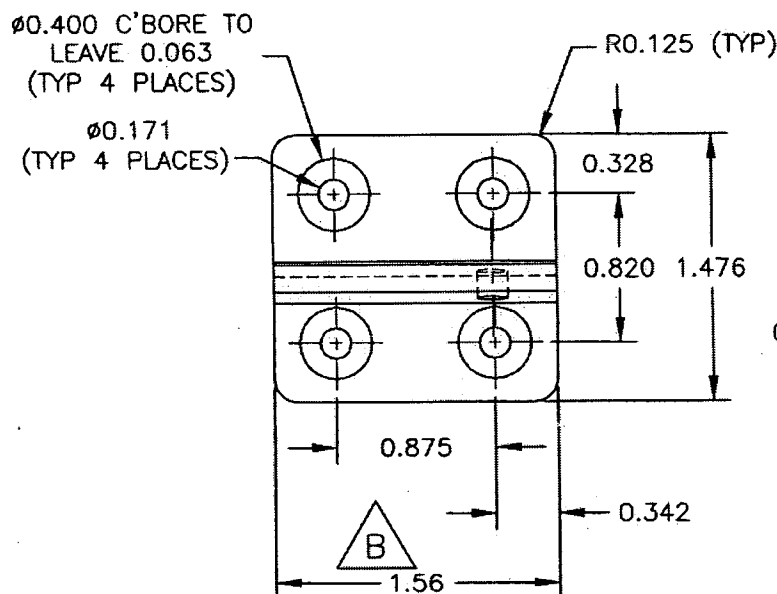
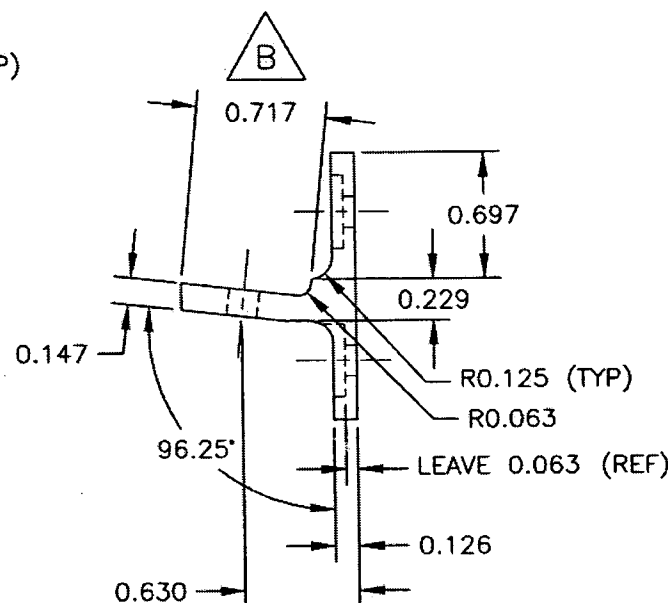
QA: N/C Closed: _____ Date: _____

DART



RELEASED
QA.01.03 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
KE	KE	
CHECKED	APPROVED	DRAWING NO.
CP	KE	D2858
DATE	TITLE	REV. B
99.02.28	HINGE BRACKET	SHEET 1 OF 1
A	NEW ISSUE	SCALE 1:1
B	99.02.28	0.717 WAS 0.667, 1.56 WAS 1.559



ENGRAVE P/N CENTERED ON
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WORK ORDER

NO. 24503

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 11, 2005
07:41 am

Work Order No : 0024503
Project Name : D2858-1
Project For : WK543
Work Order Type : Main
Main WO Number :
House Part Number : D2858-1
Description : Hinge Bracket
Manufactured : Yes
Amount Req'd : 24
Amount Done : 0
Start Date : 10-08-05
Est Finish Date : 10-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order:	24503
Description: HINGE BRACKET		Part Number:	D2858-1
Inspection Dwg: D2858 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.400 (above)	±.010	.398	✓			
.063 thick	±.010	.067	✓			
Ø.171	±.005 ±.001	.174	—			
R.125	±.010	.125	—			
.328	±.010	.328	✓			
.820	±.010	.817	✓			
1.476	±.010	1.478	✓			
1.56	±.03	1.576	✓			
.875	±.010	.872	✓			
Ø.166	±.005 ±.001	.167	—			
.254	±.010	.254	—			
R.354	±.010	.354	✓			
.965	±.010	.972	✓			
R.125	±.010	.125	✓			
96.25°	± 1/2°	96.25	✓			
32.7°	± 1/2°	32.7	✓			
.147	±.010	.138	✓			
.717	±.010	.720	✓			
.697	±.010	.697	✓			
.229	±.010	.232	✓			
.126	±.010	.122	✓			
.670	±.010	.636	✓			
.342	±.010	.342	✓			

Measured by: <u>SG</u>	Audited by: <u>J.G.</u>	Prototype Approval:
Date: <u>09.10.22</u>	Date: <u>05/10/22</u>	Date: <u>N/A</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	